

Date: Wednesday, 01/10/2008 11:46:33 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CUP
Job Number	: 42377		
Estimate Number	: 13106		
P.O. Number	:	Part Number	: D30093
This Issue	: 01/10/2008 S.O. No. :	Drawing Number	: D3009 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 42376	Material	:
Written By	:	Due Date	: 08/10/2008 Qty: 500 Um: Each
Checked & Approved By	: <u>mf 08-10-01</u>		
Comment	: Est. A 07.12.18 new issue EC Est Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304R1000	304 round bar 1.00
-----	-----------	--------------------



Comment: Qty.: 0.0503 f(s)/Unit Total: 25.1475 f(s)
 304/316 SS ROUND BAR
 Material: AISI304/316 SS 1.00" Ø Round Bar
 (M304R1000)
 Batch: M109508

502 mf 08/10/12

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: 1-TURN AS PER FOLIO FA130 & DWG D3009
 FOLIO REV: A
 DWG REV: 13

2-DEBURR AS REQUIRED

SA 502 mf 08/10/12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 502 mf 08/10/12

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

mf 08/10/13 500

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: 59

8/10/14 506x SCP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 01/10/2008 11:46:33 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUP

Job Number: 42377

Part Number: D30093

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/15 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

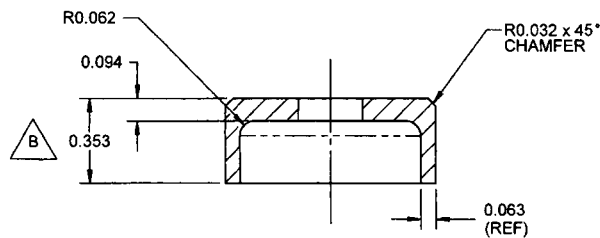
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

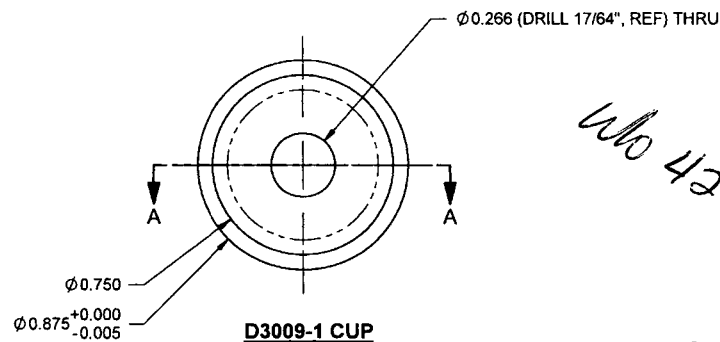
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A



D3009-1 CUP

RELEASED
08-01-07

NOTES:

- 1) MATERIAL: AISI 1018-1025 ROUND BAR
(REF DART SPEC M1018-R)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

B	REDRAW/REFORMAT DWG. D3009-1 MAT'L WAS 1010-1025 NOW 1018-1025 (A8), 0.353 WAS 0.353 (D7), Ø0.266 WAS Ø0.267 (C5), ADD D3009-3 (SHEET 2)	CP	07.12.12
A	NEW ISSUE	RF	01.03.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3009** REV. B
SHEET 1 OF 2
TITLE **CUP** SCALE 2:1

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FOR OFFICE USE ONLY

Wb 42377

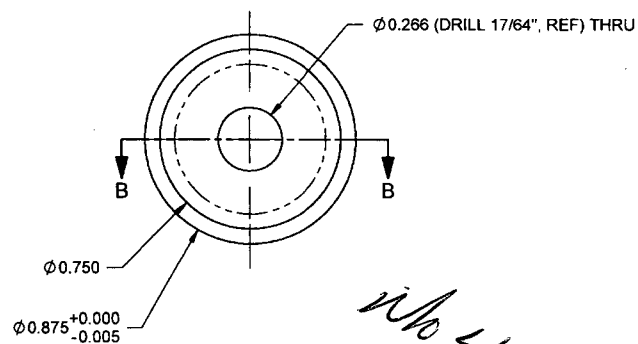
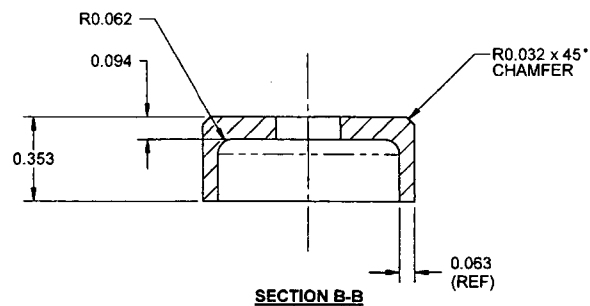
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3009-3 CUP

W/ 42377

REFERENCE ONLY

RELEASE
08-01-07-10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
(REF DART SPEC M304R)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3009	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CUP	2:1
DATE	07.12.12	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: 8/10/03
Supplier: MAGNA

Batch No: M109508
Dart P/O: 7287

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☐ No ☒ N/A ☐
Shipment Complete: Yes ☒ No ☐ N/A ☐
QC6 Inspection ☒ N/A ☒
Work Order ☐ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

08/10/06
RY 9108
CS

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

RECEIVED OCT 16 2008

10/09/08 14:54:04

Merchandise:	710.00
Surcharges:	25.00
No Tax Costs:	
GST	36.75
Total Due:	771.75

Title to the goods sent out on this invoice remains with Magna Stainless until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

Q.S.T. # 1213236471
G.S.T. # 881565899 RT0001

space Ltd
 erdeen St
 sbury, Ontario K6A 1K7
 ne: (613) 632-3336
 x: (613) 632-4443

Purchase From:

Magna Stainless
 525 avenue Meloche
 Dorval, QC H9P 2W2
 Canada

Ship To:

Main Finished Goods Location
 Dart Aerospace Ltd
 1270 Aberdeen St
 Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-MAG002	PO00007287

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M303R0500	303 Round Bar 0.500"	48.0333	f	2.450000	117.68	Oct 06, 2008
		(NOTE: AISI 304/316 NOT ACCEPTABLE) MATERIAL: AISI 303 ROUND BAR B/N109508					
	M304R1000	304 round bar 1.00	75.0000	f	8.500000	637.50	Oct 06, 2008
		(NOTE: AISI 303 NOT ACCEPTABLE) MATERIAL: AISI 304/316 ROUND BAR B/N109508					

Comments:



magna stainless
525 Meloche Avenue, Dorval, QC H9P 2W2
Phone: (514) 631-1211 Watts: 1-800-363-6646 Fax: (514) 631-0013

Page: _____

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY , ON
K6A 1K7
Contact: CHANTAL

HAWKESBURY , ON
K6A 1K7
Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

STOCK

Contact: CHANTAL		SHIP FORMS: 1000				
Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	7287	
Sales Order	Terms	Ship Via		Date Ordered	Date Required	Date Shipp
W001398	NET 30 DAYS	TARGET		10/02/08	10/03/08	10/03/08

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
4		PC	STAINLESS ROUNDS SRB 303 1/2" x R/L			
			12'1" 32 LB / 4 PC	L009029	14523	4
6		PC	SRB 304 1" x R/L			
			12'5" 202 LB / 6 PC	L015199	419280	6
			FUEL SURCHARGE			
Bundles: 1			Total Weight: 234 LB			

PC 8/1/03

Received by: _____ Date: _____ Signature: _____

Acciaierie Valbruna S.p.A.



CERTIFICATO DI COLLAUDO ABNAHMEPRUEFZEUGNIS INSPECTION CERTIFICATE CERTIFICAT DE RECEPTION EN 10204 , 3.1

36100 VICENZA (Italia) - Viale della scienza, 25 z.i.
Stab.: 39100 BOLZANO (Italia) - Via A. Volta, 4

Cliente / Besteller/Purchaser/Client
VALBRUNA CANADA LTD
8724 HOLGATE CRESCENT
CDN-MILTON, ONT L5T 5Z1-CAN

Produttore: ACCIAIERIE VALBRUNA S.P.A.
Hersteller/Item/Usine productrice

Oggetto Prove: - Annealed Cold Drawn
Prüfgegenstand/Item Inspected/Finissage

Avviso di Spedizione: D-VI07007544
Lieferanzeige/Packing Est/B.L.

Ordine nr: 702001762 STOCK
Bestell/Your order/Commande

Tipo di Elaborazione: E+AOD
Erschmelzungsart/Melting process/Mode d'elaboration

Certificato nr: MEST466400/2007/
Prüfung/Test/Essai

Conferma ordine nr: EI07001200
Werks/Our Order/Ref nr.

Marchio di Fabbrica:
Zeichen des Lieferwerkes
Trade mark
Sigle de l'usine productrice

Punzone del Collaudatore:
Stempel des Werksachverständigen
Inspector's stamp/Plaque de l'essayeur



Specifiche:
Anforderungen / Requirements / Exigences

VAL CANADA 2 304/304L A,CF
ASME SA182 2004 S30400/03
ASME SA479 2004 S30400/03
ASTM A262 2002A PRACTICE E
ASTM A320 2005A B8
NACE MR0175 2003 S30400/03 A s
(0) SEC.II PT.A 2004 EDITION ADD.2006
(1) SEC.II PT.A 2004 EDITION ADD.2006
(3) SEC.II PT.A 2004 EDITION ADD.2006
(5) * ISO 15156-3

AMS 5639 H S30400
ASME SA193 2004 B8 1
ASTM A182 2006 S30400/03 4
ASTM A276 2006 S30400/03
ASTM A479 2006 S30400/03
QQ-S-763 F 304/304L

AMS 5647 H S30403
ASME SA320 2004 B8 (2)
ASTM A193 2006A B8
ASTM A314 97 S30400/03
MIL-S-862 B/1 304/304L

0Chemical analysis only.
2SEC.II PT.A 2004 EDITION ADD.2006
4Chemical analysis only.

Qualità: T-304L
Werkstoff/Grade/Qualité

Marca: MVAISL MAXIVAL
Markenbezeichnung/Brand/Qualité

Punzonatura: T-304L
Kennzeichnung/Marking/Qualité

Pos. nr. Pos. nr. Nr. de poste	Oggetto Gegenstand Product description Descr. du produit	Dimensioni - In Abmessungen Dimension Dimension	Tolleranza Toleranz Allowance Tolerance	Lunghezza - Ft Länge Length Longueur	Colata Schmelze Heat Coulée	Pezzi Stückzahl Pieces Pièces	Peso - LB Gewicht Weight Poids	Lotto nr. Losnr. Lot nr. Lot nr.
0030	Round	1,0000	484-05A	12 / 12	419280		18.116	703905280

Sono state soddisfatte tutte le condizioni richieste
Die gestellten Anforderungen sind i. Anlage erfüllt
The material has been furnished in accordance with the requirements
Le matériel a été fourni conforme aux exigences

Controllo antimiscelazione: OK
Verwechslungsprüfung: spektralanalytisch durchgeführt
Antimixing testing performed: OK
Contrôle antimélange fait: r.a.s.

Controllo visivo e dimensionale: soddisfa le esigenze
Besichtigung und Ausmessung: ohne Beanstandung
Visual inspection and dimensional checks: satisfactory
Contrôle visuel et dimensionnel: satisfaisant

TEST	Provetta/Probestab Spezimen/Éprouvette Length/Diam. Breite/Diam. Länge/Diam. mm	°F	Posiz. Saggio Position Lage Position	Snervamento Streckgrenze Yield Stress Limite élastique Rp 0,2% k.s.i.	Snervamento Streckgrenze Yield Stress Limite élastique	Resistenza Zugfestigkeit Tensile strength Résistance à traction Rm k.s.i.	Allungamento Bruchdehnung Elongation Allongement E 4d %	Strizione Einengung Reduction of area Striction RA %	Resilienza Kerbschlagarbeit Impact Value Resilience	Durezza Härte Hardness Dureté HB 1/2 r.
Valori richiesti 1 Anforderungen/Required values Valeurs demandées		min max		30	-	75	- 40	- 50	-	140 223
A	12,5	68	L	72		99	45	67		220

1) L=longitudinale/länge, Q=trasversale/quer, T=Tangenziale/tangential

Grain size for ASTM E112 : 5

Analisi chimica

Chemische Zusammensetzung/Chemical Analysis/Analyse chimique

Colata / Heat Schmelze/Coulée	min - max 0,030	1,00	2,00	18,00 20,00	1,00	1,00	8,00 10,50	0,040	0,030	0,100	-	-	-	-
C %	Si %	Mn %	Cr %	Mo %	Cu %	Ni %	Co %	P %	S %	N %				
419280	0,018	0,57	1,79	18,07	0,46	0,72	8,15	0,076	0,026	0,027	0,096			

Produced without class I-II Ozone depleting substances.

Solution heat treated free from continuous carbide network.

Annealing temperature: 1960°F for 1 H/H2O.

Micro and macro etch test: OK

Intergranular corrosion test per ASTM A262 pract. E: ok.

Material is DFARS Compliant

Melted and manufactured in Italy No welding or weld repair Material free from Mercury or radio-activity contamination
The Quality Management System is Certified acc. Pressure Equipment Directive [97/23/EC] Annex 1, s. 4.3 by TUEV and LLOYD'S

Vicenza, 09/03/07

CO008
(Mod. MCER)

Il collaudatore di stabilimento / der Werkssachverständige / Works inspector / L'agent d'usine

M. Rizzotto

Pagina - 1 di 1